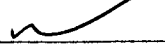


Date: Wednesday, 20/09/2006 8:34:14 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BEARING ASSEMBLY	
Job Number :	28653	Part Number :	D3183045	
Estimate Number :	11136	Drawing Number :	D3183 REV C1	
P.O. Number :	N/A	Project Number :	N/A	
This Issue :	20/09/2006	Drawing Revision :	C1	
Prsht Rev. :	NC	Material :	N/A	
FIRST ISSUE :	N/A	Due Date :	27/09/2006	Qty: 8 Um: Each
Previous Run :	28622	Type :	MACHINED PARTS	
Written By :				
Checked & Approved By :				
Comment :	Est A04.02.18 New issue KJ/DS			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MDELNR1000	Delrin Round Bar 1"
-----	------------	---------------------



Comment: Qty.: 0.0350 f(s)/Unit Total : 0.2797 f(s)
 Delrin Round Bar 1"
 Material: Ø1.00 Delrin Rod
 (M-DELRIN-R1.000)
 Identify as D3183-9
 Batch: _____

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
 Turn D3183-9 Cap as per Folio FA388
 Deburr

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	D31835	Bearing
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Pick:

Qty Part Number	Description	Batch
1 D3183-5	Bearing	615 1993 9

2 B 23979

Date: Wednesday, 20/09/2006 8:34:14 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 28653

Part Number: D3183045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

D3183-9 B28296

GAD 06:09:20 (8)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/20 8

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

u 0609.20

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SP 06/09/21 (8)

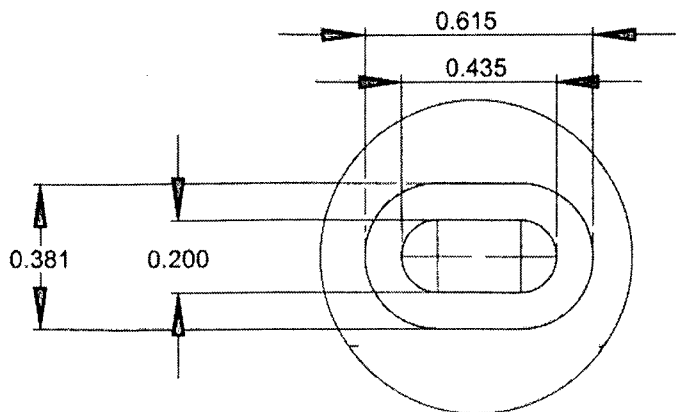
Job Completion



u 0609.20

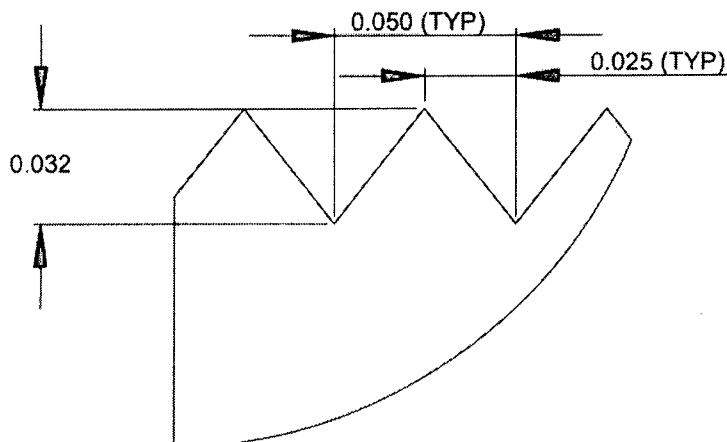


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

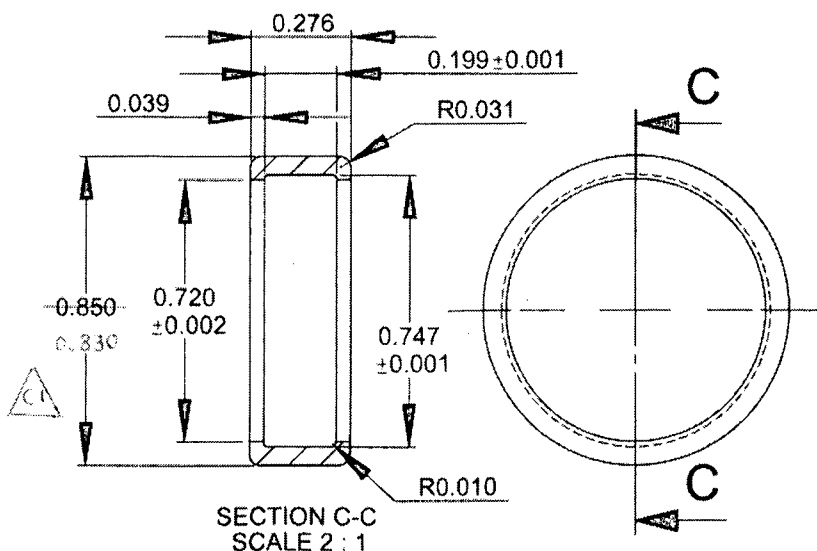


DETAIL A (2 : 1)

RELEASED
04.03.01



DETAIL B (20 : 1)



SECTION C-C
SCALE 2 : 1

REFERENCE ONLY

D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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